

Date: Tuesday, 8/7/2007 5:34:24 PM
User: Jean-Luc Menard

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : PANEL |
| Job Number | : 33839 | | |
| Estimate Number | : 10872 | | |
| P.O. Number | : N/A | Part Number | : D32452 |
| This Issue | : 8/7/2007 | Drawing Number | : D3245 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A | Drawing Revision | : A |
| Previous Run | : N/A | Material | : N/A |
| Written By | <u>JLJ 07-08-07</u> | | |
| Checked & Approved By | | | |
| Comment | Est. A 04.07.07 New issue KJ/JLM | | |

Additional Product

| | |
|-------------|-----------------------------------------------------------------------------------|
| Job Number: |  |
|-------------|-----------------------------------------------------------------------------------|

| Seq. #: | Machine Or Operation: | Description : |
|---------|--------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------|
| 1.0 | M304S22GA | 304/316 .032 Sheet  |
| X | Comment: Qty.: 0.8442 sf(s)/Unit Total : 0.8442 sf(s) 304/316 .032 Sheet Batch: M105061 | SAB 07/08/07 |
| 2.0 | WATER JET | FLOW WATER JET  |
| | Comment: FLOW WATER JET 1-Cut as per Dwg D3245 ****prog.D3245-1/-2**** Dwg Rev: A Prog Rev: A | (No Holes) JDL SAB 07/08/07 |
| | 2-Deburr if necessary | ① |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE  |
| | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | SAB 07/08/07 |
| 4.0 | QC8 | SECOND CHECK  |
| | Comment: SECOND CHECK | JUL 07-08-08 |
| 5.0 | BRAKE NC | NC BRAKE  |
| | Comment: NC BRAKE Deburr if necessary C'sink as per Dwg D3245 Form D3245-1 as per Dwg D3245 Identify as D3245-1 | MF 07-08-09. SAB 07/08/07 |

Date: Tuesday, 8/7/2007 5:34:25 PM

User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 33839

Part Number: D32452

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

en 07/08/09 (X) -042

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

JL 07-08-10

(1)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

en 07/08/10

(1)

Job Completion



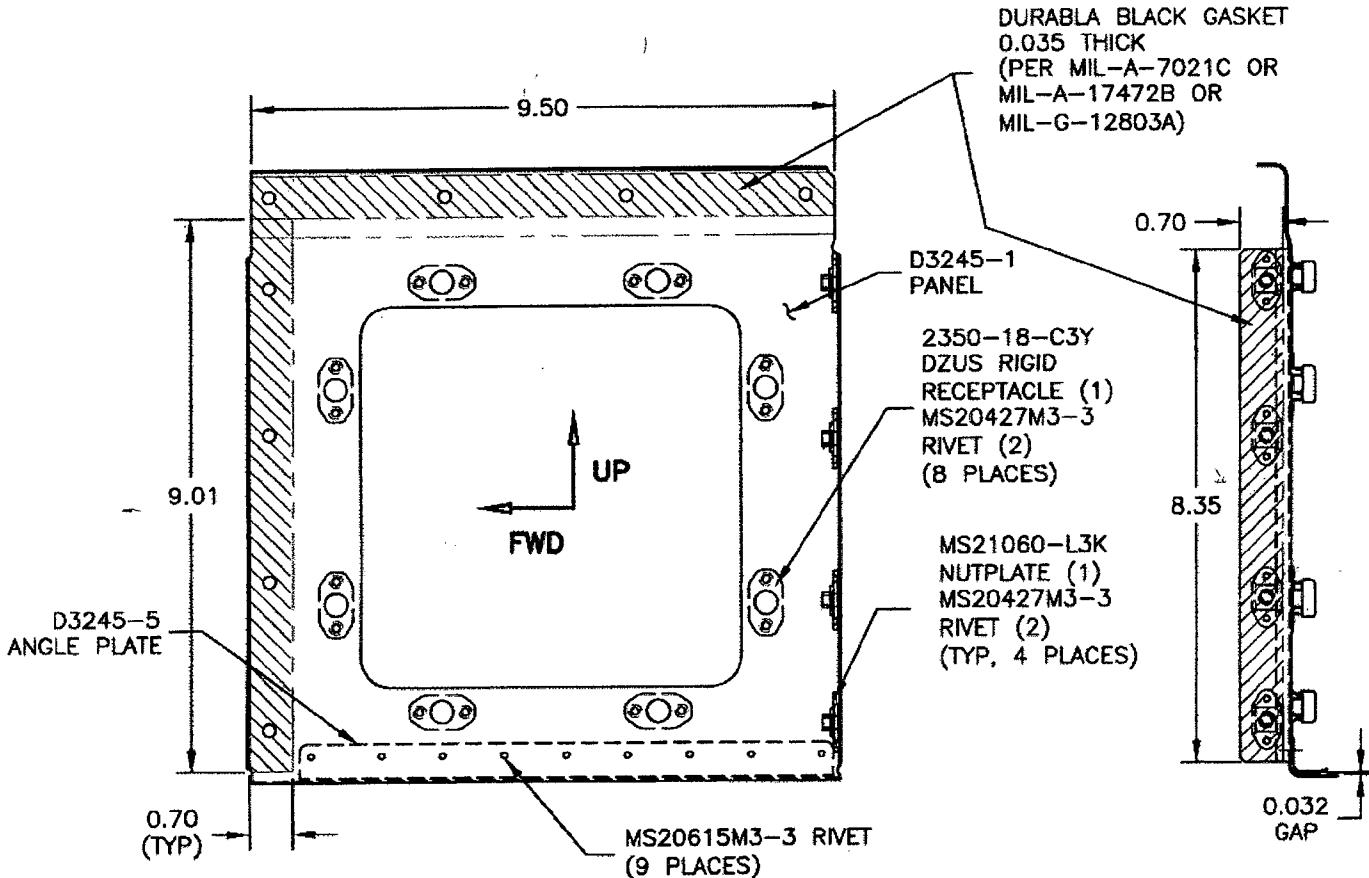
JL 07-08-10



OF COPY ISSUED

| | | | |
|----------------------|-----------------------|---------------------------------------------------|------------------------|
| DESIGN RF | DRAWN BY <i>IP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>HF</i> | APPROVED <i>HF</i> | DRAWING NO. D3245 | REV. A SHEET 1 OF 6 |
| DATE 04.01.27 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:13 |
| A | 04.01.27 | NEW ISSUE | |

RELEASED
04.04.21



D3245-041 ACCESS PANEL ASSEMBLY

D3245-041 NOTES:

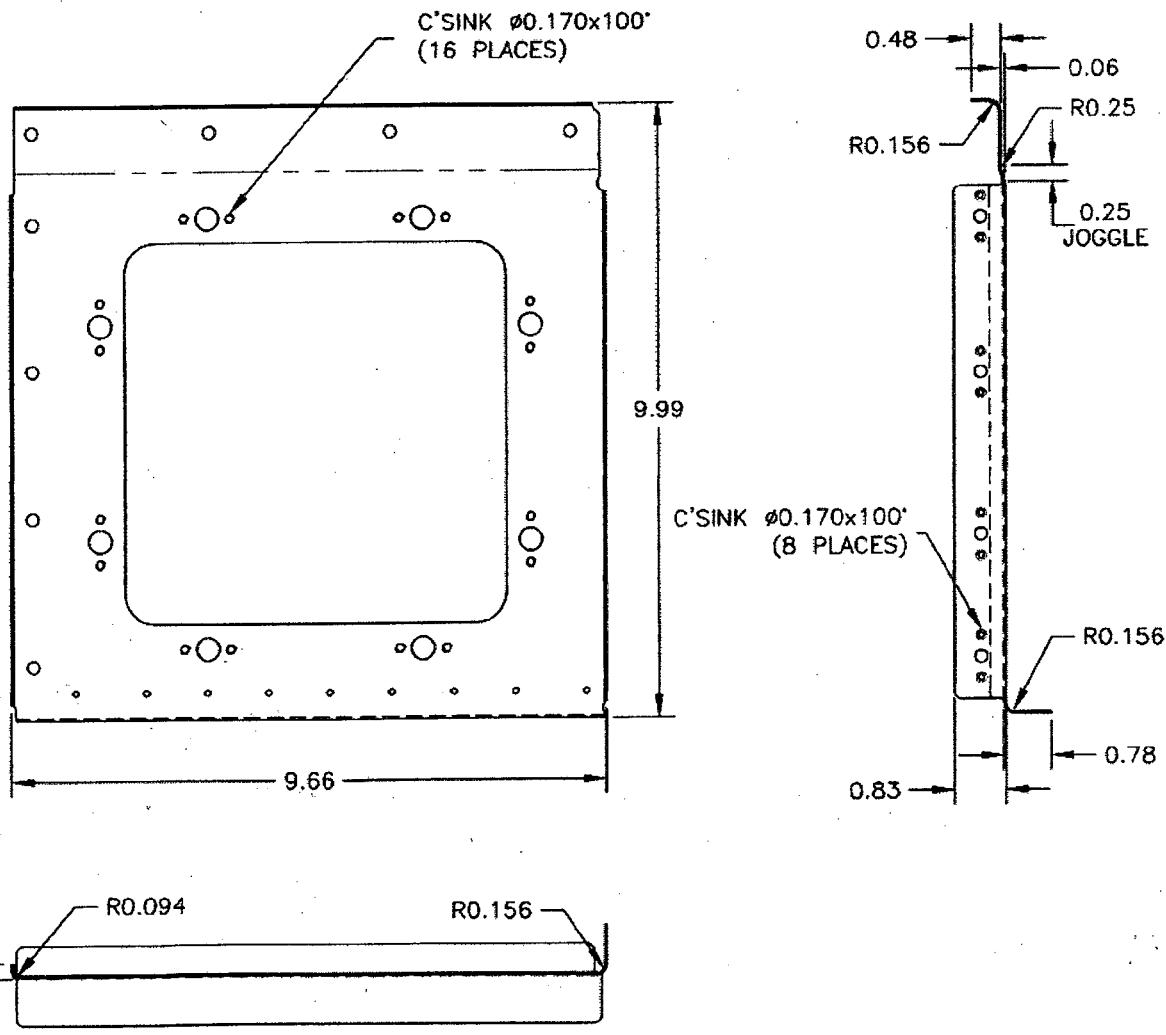
- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

| | | | |
|---------------------|-----------------------|---------------------------------------------------|------------------------|
| DESIGN RF | DRAWN BY <i>AP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>✓</i> | APPROVED <i>✓</i> | DRAWING NO. D3245 | REV. A SHEET 3 OF 6 |
| DATE 04.01.27 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:3 |

RELEASED
04.04.21 *✓*

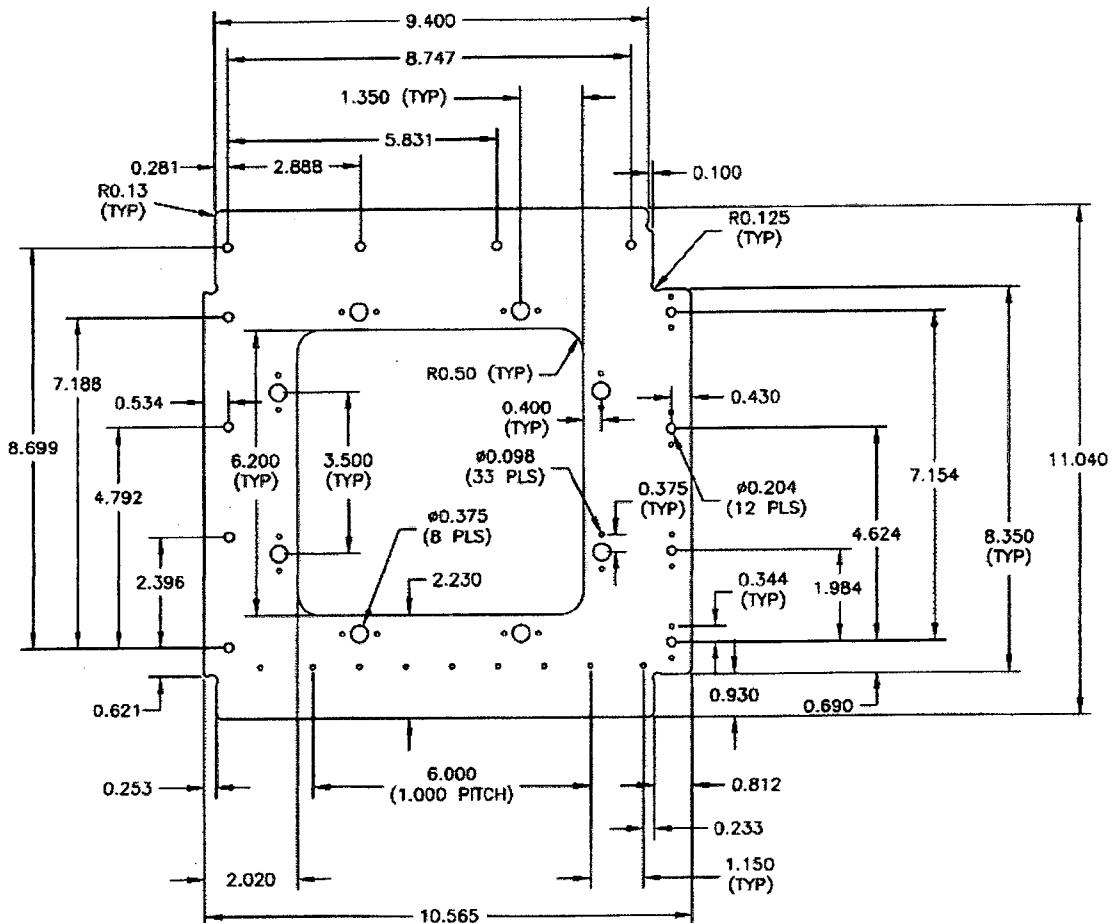
D3245-1 PANEL BEND DETAIL SHOWN
BEND D3245-2 PANEL OPPOSITE



A circular stamp with the words "COPY ISSUED" printed around its perimeter.

| | | | | |
|----------------------|--------------------------------|---------------------------------------------------|--------------|--------------|
| DESIGN RF | DRAWN BY <i>RP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>ff</i> | APPROVED <i>ff</i> | DRAWING NO. D3245 | REV. A | SHEET 4 OF 6 |
| DATE 04.01.27 | TITLE ACCESS PANEL ASSEMBLY | | SCALE 1:4 | |

RELEASER
04-04-21



D3245-1/-2 PANEL FLAT PATTERN

NOTES:

- NOTE

 - 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 - 2) ALL DIMESIONS ARE IN INCHES
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33838 |
| Description: Panel | Part Number: | D3245 |
| Inspection Dwg: D3245 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|----------|-------------|--------------------|---------------------|--|
| Measured by: | SAN | Audited by: | <i>[Signature]</i> | Prototype Approval: | |
| Date: | 07/08/08 | Date: | 07-08-08 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|----------|------|-----------------------------------------------------------------------------------------------------|--------------------------------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/08/09 | 6.1 | 8 2350 - 18C3X Batch M19688 ✓ 16 M5 20427H 3-3 Batch M101840 ✓ 9 M5 20B15H 3-3 Batch M17654 ✓ | | | MF | 07-08-09 | 1 | | 07-08-09 |
| | | 1 D 3245-5 Durable Black Gasket 1 .70Q X 8.35 1 .70Q X 9.50 1 .70Q X 9.01 | Batch B 33837 Batch B 23711 | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector | |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries